

ALO 199

Back hardening and tempering, tooth hardening and hot straightening of carbon steel band saw blades



THE SYSTEM COMPRISES:

Back hardening generator and inductor
Back tempering generator and inductor
Tooth hardening generator and inductor
Straightening generator and inductor
Closed cooling system
Band feeder
Quench system
Universal clarifier for the quenchant

CAPACITY:

Band width: 6 - 32 mm
Band thickness: 0.64 - 1.07 mm
Tooth pitch: 1 - 14 tpi
Speed capacity: 5 - 9 m/min

OPTIONS / ACCESSORIES:



ALO 822
Double coiler



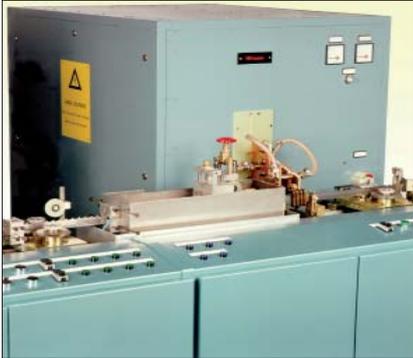
ALO 831
Double coiler



ALO 880
Electric coiler



ALO 106 CUBE
Coil handling system



Back hardening unit



Tempering unit

MACHINE DESCRIPTION

Band feeder

The band feeder consists of two units, one 6-wheel feed unit, the other as an 4 wheel adjustable tension control using a electro magnetic friction brake. The six rolls on the feed unit are driven by a servomotor, and the speed is controlled by a servo controller. The inductors are located between the brake and the feed units such that the band is pulled through the inductors at a controlled tension.

Generators

The generators are enclosed in separate aluminium cabinets. The tooth hardening and straightening generators are air cooled, while the back hardening and tempering are water cooled. The tooth hardening generator are equipped with a chopper for infinitely variable control of the output power.

Inductors

The inductors are made of copper tubing and can be custom made for different pitches and band gauges. They are adjustable in height for different blade widths and sideways for different blade gauges. The inductors are interchangeable and can easily be replaced. The inductors for back hardening are made of copper and designed for uniform heating of the whole of the bandsaw blades. They are easily exchangeable for service or replacement.

TECHNICAL SPECIFICATION:

Band width:	6 - 32 mm
Band thickness:	0.64 - 1.07 mm
Tooth pitch:	1 - 14 TPI
Capacity:	5 - 9 m/min
Air pressure:	6.3 bar
Standard voltage:	400VAC $\pm 10\%$ 3-phase, 50-60 Hz $\pm 1\%$ directly earthed system, other voltages available upon request.
Power consumption (at max output power):	95 kVA
Weight:	900 kg
Space requirement (l x w)	8 x 2 m

Other customer requirements may be discussed between customer and ALO.